

GREEN

Dart Aerospace Ltd.

Date: Wednesday, 9/6/2006 3:53:23 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28452
 Estimate Number : 10178
 P.O. Number : N/A
 This Issue : 9/6/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 28014
 Written By :
 Checked & Approved By :
 Comment : Est D 02.08.02 Make in Cobra KJ

Drawing Name : PLUG
 Part Number : D25941
 Drawing Number : D2594 REV B1
 Project Number : N/A
 Drawing Revision : B1
 Material : N/A
 Due Date : 9/30/2006 Qty: 96 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0625 6061-T6 Round Bar .625"



Comment: Qty.: 0.0547 f(s)/Unit Total : 5.2517 f(s)
 Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)
 1100-0 (QQ-A-225/1) Ø0.625" Rod
 (M5052H32R0.625) or (M6061T6R0.625) Batch 10/421-75.2517

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
 1-Make as per Dwg D2594-1 and Folio FA262.
 2-Break all sharp edges 0.010 max.

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Acid etch and alodine as per QSI 005 4.1

0.11 06-10-02

96

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA ☒ Date: 06/10/03

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 9/6/2006 3:53:23 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 28452

Part Number: D25941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

am 06-10-02

(96)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 10 02

(96)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(96)

Comment: FINAL INSPECTION/W/O RELEASE

06/10/03

Job Completion



U 06-10-03

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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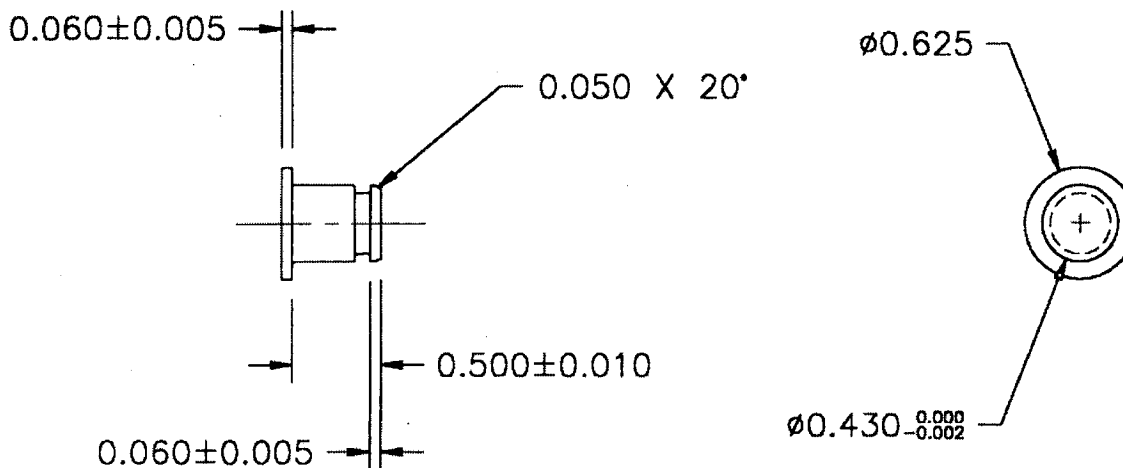
NOTE: Date & initial all entries



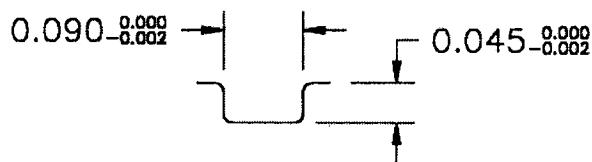
| | | | |
|------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>BW</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2594 | REV. B SHEET 1 OF 1 |
| DATE 96:09:16 | | TITLE PLUG | SCALE 1:1 |
| B | 97:03:15 | ADD GROOVE AND O-RING | |
| B1 | RF 02.08.26 | ADD POWDER COAT, QSI 018, & QD-A SPECS. | |

D2594-1 PLUG:

RELEASED
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.S.1) PER QSI COS 4.3

PER QD-A-225 / 7 (5052)
OR QD-A-225 / 8 (6061)
OR QD-A-225 / 1 (1100)
OR QD-A-200 / 8 (6061)

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)

D2594 PLUG ASSEMBLY INCLUDES:

- (1) D2594-1 PLUG
- (1) D2594-3 O-RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28452